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Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
	•					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	١o.					Scrap		,	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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Root					Desc	ription of work order update	i	nitial	Action		Sign &		
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	-	Bending			$\vdash$	Bend	<u> </u>	1	rogram	<u> </u>	Outside Dim	<u> </u>	Pressure/Forced
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	<u> </u>	Cracks	l (D: 1		-	Broken/Damage/Defect	┡	Hardwa			Part Incorre	<u> </u>	Temperature/Cure
	-	Crimp/Kink/Ripple/Wave			-	Burrs	<u> </u>	1 '	ion Incomplete/Ui	` <b>⊢</b>	Part Lost/M	- <u>-</u>	Weld
	-	Couffs			-	Countarink		-	ions Incomplete/U	Unclear	Part Moved	<u> </u>	Wrong Stock Pulled
	Crushing				-	Countersink	$\vdash$	Mislabe	gned/off center		Positioned V		70.50
	Heat Treat			$\vdash$	Cut Too Short	-	1		L	Power Loss/	ourge	Other	
	Inspection Strip in Tube Marks/Chatter				Drawing Drill Holes	-	Misread Off-set						
	-	1			-	Finish	$\vdash$	4	Calibration		·		
	Turning Sequence				-	Fit/Function	$\vdash$	-1	Sequence				
	Wave/Twist in Tube					Tridi anction	L	Tout of 3	sequence				

Work'Ord March-04-14 3		4405		*11	440	5*		77.6				Page 2
Item ID: Revision ID: Item Name:	D3601-1 Radius Block		The state of the s	Accept	*N	900	<b>040</b>	100	)*	Setup Sta	1 /1	S1* S2*
Start Date: Required Date: Reference:	04/03/2014	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*	l.		ust Item II ustomer:	D:				I	
Approvals:		n:	Date:	Tooling: SPC (Y/N):			te:		]	Run Sta Sta	op	R1* R2*
Sequence ID/ Work Center II 130 *1 20* QC Quality Control	D /	Operation Description QC8- Inspect parts - second	nd check	Set Up/ Run Hours 0.00		ГооІ ID 14/03	Tool#	Plan Code	Accept Qty	Qty	Reject Number	Insp. Stamp  DAS 14 9-89
140 *140* Small Fab Small Fab		Small Fab  Memo 1-Tumble 2-Deburr any	rough edges after tumbli	0.00 0.00					41x =	H 17	- 3.19	- 14 fa3 f1 z
150 <b>*150*</b> HandFinish		Chemical Conversion Co	at per QSI005 4.1	0.00					41	H	6143	-19

Hand Finishing

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			_			WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE			_		AÉROSPACE
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Work'Ord  March-04-14 3		4405		*1144	405*							Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3601-1  Radius Block 04/03/2014 : 04/03/2014	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*	Accept	*N900 Cust Item Customer:	ID:	100	<b>)</b> *	Setup	Start Stop		IS1* IS2*
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:			Run	Start	"IX	IR1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	IR2*
Sequence ID/ Work Center I  160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 DAS 27 9-89 0.00 \U\3	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location: SAS 6	0.00			4	<u>'\</u>		DAS O6 <del>249</del>	e de la companya de l	MAR 2 0 2014 — ———
180 <b>*1 2 \^*</b> QC Overlity Control		QC21- Final Inspection -	Work Order Release	0.00				<u>M</u>	レン	14	03-7	21-03-2
Quality Control											MC	5 14050

DQA: Date:						1440DW 0DDED 440A								*		•
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raitiv					-	Scrap Use-as-is			Machining noforming	Finishing		1	d. Eng. Coor. re/Packaging	$\dashv$	Quality Other	
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**Picklist Print** 

March-04-14 3:04:50 PM

Work Order ID: 114405

\*114405\*

Parent Item:

D3601-1

\*D3601-1\*

Parent Item Name: Radius Block

Start Date: 04/03/2014

et.

Required Date: 04/03/2014

**Start Qty: 40.00** 

Required Qty: 40.00

**Comments:** 

IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1		Purchased	No			f	57.0920		3			

\*M6061T6B00750X00 125\*

6061-T6 Bar .750 x .125

Location Loc Oty Loc Code MAT049 57.092 M/02/11 M127818 57.092

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DQA:			Date:			WORK ORDER NON	~	NICOI					*DART
QA Closed:			Date:			WORK ORDER NON-	٠. د د	JINFUI	RIVIAINCE / UI		Vork Order up	odate only	AÉROSPACE
Work Orde						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WORK OTGE	- '				<del></del>	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	10					Scrap			Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	<b>'</b> '					Use-as-is	ı		noforming	Finishing	<b>—</b>	re/Packaging	Other
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		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	ire	_	Part Incorre		Temperature/Cure
	_	Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld
	ш	Cuffs				Contamination		1	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
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		Marks/Ch				Drill Holes		Off-set					
	-	Turning S				Finish		i .	Calibration				
	$oxed{L}$	Wave/Tw	ist in Tub	oe		Fit/Function	L	Out of	Sequence				

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DART AEROSPACE LTD	Work Order:	114405
Description: Radius Block	Part Number:	D3601-1
Inspection Dwg: D3601 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	6.749				
0.375	+/-0.010	0.370				
0.375	+/-0.010	0.375				
Ø0.257	+0.006/-0.001	0.257				
0.357	+/-0.010	0.355				
R0.38	+/-0.030	0.379				
0.80	+/-0.030	0.809				
0.3 x 45°	+/-0.010 x 0.5°					

Measured by:	Audited by:	on DAS	Preliminary Approval:	
Date: 14 -03 15	Date:	14/03/12	Date:	

Rev	Date	Change	Revised by Approv
Α	07.05.08	New Issue	KJ/JLM ,
В	11.08.22	Dimensions updated	KJ KJ

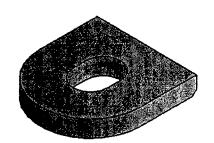
DQA:	Date:												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Nork Order uj	odate only	AEROSPACE
Mork Orde						DISPOSITION				-	DEPARTMENT	· · · · · · · · · · · · · · · · · · ·	
Work Orde	_					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	_	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Desci	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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							FAL	ULT CAT	regory				
Landi	B C C C C C I In	ending entre No racks rimp/Kin uffs rushing eat Trea	Strip in	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct	ion Incomplete/Ur ions Incomplete/U ned/off center eled	· +	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	_	equence			Finish		<del>1</del>	Calibration				
, 1	, Wave/Twist in Tube			- 1	Fit/Function	1	Out of 9	Sequence					

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	BI	DRAWN BY	DART AEROSPACE L' HAWKESBURY, ONTARIO, CANA	
CHECK	ED A	APPROVED	D3601	REV. A SHEET 1 OF 1
DATE	07.0	02.13	TITLE RADIUS BLOCK	SCALE 2:1
REV		DATE 07.02.13	DESCRIPTION NEW ISSUE	

07.03.08



SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE 0.75 WORK ORDER NO 71470 1403-05 0.375 R<sub>0.38</sub> 0.80 0.375 CHAMFER  $_{0.03}^{0.05}$  x 45°OR **OBROUND**  $\emptyset$  0.257 x 0.357 FILLET R  $\begin{array}{c} 0.05 \\ 0.03 \end{array}$ 

## D3601-1 RADIUS BLOCK

NOTES:

1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR
ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed: Date:						Work Order update only								
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
						Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part No.						Scrap		Machining Small Fab			Prod. Eng. Coor.		Quality	
						Use-as-is		Therr	Thermoforming Finishing			re/Packaging	Other	
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,		Cracks				Broken/Damage/Defect Н		Hardwa	Hardware		<b>⊣</b>		Temperature/Cure	
		Crimp/Kink/Ripple/Wave				Burrs		Inspect	nspection Incomplete/Unqualified		Part Lost/Missing		Weld	
•	-	<del>-</del>				Contamination		Instructions Incomplete/Unclear		Jnclear [	Part Moved		Wrong Stock Pulled	
		<del>-</del>				Countersink		Misaligned/off center			Positioned \	Wrong	_	
	-	Heat Treat				Cut Too Short		Mislabe	eled				Other	
<del></del>		1 . <del>   </del>				Drawing	Misread		t			¥.,		
	Marks/Chatter			1		Off-set	Off-set							
	Turning Sequence			Finish		Out of Calibration								
	Wave/Twist in Tube			- 1	Fit/Function		Out of Sequence							

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